

Work Order ID 134664

Tuesday, July 14, 2015 2:44:08 PM

134664

~~PRELIMINARY ISSUE~~

Page 1

Item ID: D5287-1

Revision ID: PRELIM

Item Name: Clevis

Start Date: 7/14/2015 Start Qty: 6.00

Required Date: 7/14/2015 Req'd Qty: 6.00

Reference:

Accept

N900040100

Setup Start *NS1*

Stop *NS2*

Cust Item ID:

Customer:

Approvals: Process Plan: MLJ Date: JUL 14 2015 Tooling: _____ Date: _____
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start *NR1*

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D5287	PAS 9 9-89

100

0.00

100

Waterjet

FLOW CNC Waterjet

Memo

cut as Dwg

Dwg Rev: PAS

Prog Rev: PAS

0.00

DEburr

101

QC2- Inspect parts off machine FAI/FAIB

0.00

101

QC

Quality Control

Memo

0.00

⑥

2-15/07/14

⑥

2-15/07/14

Work Order ID 134664

Tuesday, July 14, 2015 2:44:08 PM

134664**PRELIMINARY ISSUE**

Page 2

Item ID: D5287-1

Accept

N900040100Setup Start ***NS1***

Revision ID: PRELIM

Item Name: Clevis

Stop ***NS2***

Start Date: 7/14/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 7/14/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

102

QC8- Inspect parts - second check

0.00

102

QC

Memo

0.00

Quality Control

(6) 15-07-14 PD

105

0.00

105

Brake NC

Memo

0.00

Brake NC

FORM AS PER DWG

DAS
30
9-896

JUL 14 2015

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

(6) 15-07-14 PD

Work Order ID 134664

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134664

~~PRELIMINARY ISSUE~~

Page 3

Item ID: D5287-1

Accept

N900040100

Setup Start

NS1

Revision ID: PRELIM

Item Name: Clevis

Stop

NS2

Start Date: 7/14/2015 Start Qty: 6.00

6

Cust Item ID:

Required Date: 7/14/2015 Req'd Qty: 6.00

6

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

140

Identify as per dwg & Stock Location:

0.00

140

Packaging

Memo

0.00

Packaging

27

9-89

JUL 27 2015

15-07-16 PD

15-07-27 PD

* 2 was ship for testing *

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

Quality Control

MCS JUL 16 2015

POSITIVE RECALL

EFFECTIVE JUL 14 2015

AUTH MCS

RELEASED 15-07-24

DATE 9-89

at Row A

ENG 6100

Picklist Print

Tuesday, July 14, 2015 2:44:11 PM

Page 1

Work Order ID: 134664

134664

Parent Item: D5287-1

D5287-1

Parent Item Name: Clevis

~~PRELIMINARY ISSUE~~

Start Date: 7/14/2015

Required Date: 7/14/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:A NEW ISSUE 15-07-13 JLM VERIFIED BY JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M304S11GA		Purchased			No		sf	133.0257		0.126316			

M304S11GA

304/316 0.125 Sheet

**

DC 15/07/14

Location

Loc Qty

Loc Code

MAT020

133.0257

122521

40.034

M128254

56

M129545

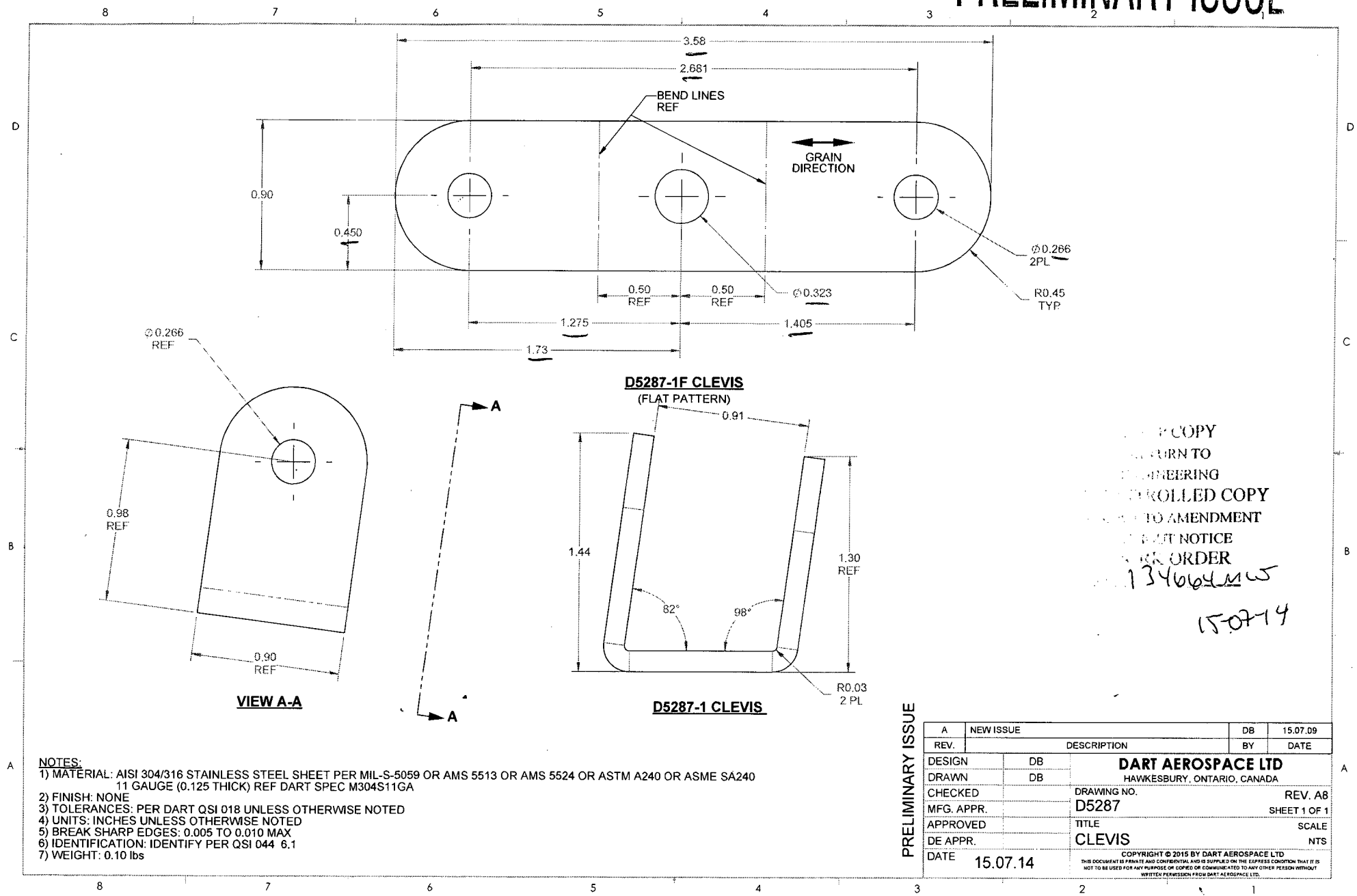
27.075

M129972

9.9167

2

PRELIMINARY ISSUE



1. COPY
 2. RETURN TO
 3. ENGINEERING
 4. ROLLED COPY
 5. TO AMENDMENT
 6. NOTICE
 7. ORDER
 134664 MW
 15-07-14

PRELIMINARY ISSUE

REV.	DESCRIPTION	BY	DATE
A	NEW ISSUE	DB	15.07.09
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	DB		
CHECKED		DRAWING NO.	REV. A8
MFG. APPR.		D5287	SHEET 1 OF 1
APPROVED		TITLE	SCALE
DE APPR.		CLEVIS	NTS
DATE	15.07.14	COPYRIGHT © 2015 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

INSPECTION SHEET

Rev	Date	Change	Revised by	Approved
B	14.07.31	New Issue	KJ	

Receiving Report

Date: 14/2/18
Supplier: COMI

Batch No: M128254
Dart P/O: 20968

Packing Slip: Yes ☒ No ☒
Invoice: Yes ☐ No ☒
Receipt: Cash ☐ Cr ☒
New Supplier Yes ☐ No ☒

Release Note Attached: Yes ☐ No ☒ N/A ☐
Waybill Attached: Yes ☐ No ☒ N/A ☐
Shipment Complete: Yes ☒ No ☒ N/A ☐
QC18 Inspection 9.14.02.20 N/A ☒
Work Order 9.80 N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Rec'd	Quantity Short	Quantity Inspected	Quantity Rejected	Comment / NCR Number
	UUR PO-NOR		30				

Initials of Receiver

QC12

Production/Admin: 14/2/18
Date
Received/Costing
Initial

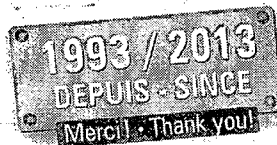
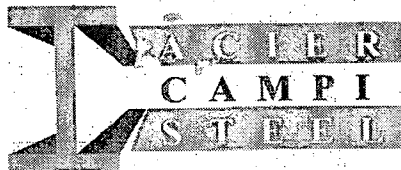
Location

Page 1 of 1

All amounts are calculated in domestic currency.

All Vendors PO ID PO22968 Receipt Dates from 2/18/2014 to 2/18/2014 All Line Item Types
All Item ID/GL/WOs All Rec. Employees All Currencies
Grouped by Vendor ID

[illegible]



935, boul. du Havre
Valleyfield, Québec
J6S 5L1

Valleyfield

Tél.: 450 377-4248
Fax : 450 377-5696

Montréal

Tél.: 514 336-4248
Fax : 514 336-4246

Ontario

Tél.: 1 800 667-4248
Fax : 1 866 456-4242

DISTRIBUTEUR D'ACIER ET DE METAUX SPECIALES
STEEL AND SPECIALTY METALS DISTRIBUTOR

VENDU À / SOLD TO :

613-632-5200

613-632-1053

EXPÉDIEZ À / SHIP TO :

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY,
ONTARIO
K6A 1K7

EQUIP: LIFT

DART AEROSPACE LTD
1270 ABERDEEN STREET
HAWKESBURY,
ONTARIO
K6A 1K7

COMMANDE
ORDER

N° 5004414

DATE

14/02/14

BON DE LIVRAISON
PACKING SLIP

N°

DATE DE LIVRAISON
DELIVERY DATE

14/05/14

VOUS / DE COMMANDE / YOUR PO. N°	VEND / SALES M.	CODE CLIENT / CUST. CODE	EXPÉDIER PAR / SHIP VIA	TERMES / TERMS	TERR.	REMARQUES / REMARKS	PAGE N°
PD22968	FL	DAER	12345	NET 30 JOURS	2R		001

CODE DE PRODUIT PRODUCT CODE	COMMANDE ORDERED	EXPÉDIE SHIPPED	DESCRIPTION	POIDS WEIGHT	PRIX PRICE	PAR PER	MONTANT AMOUNT
	12	B/O	58303 SQUARE BAR 1"	12.00			
			X 12' R/L				
PSS12303	48	B/O	S.S. 303 ROUND 1/2"	32.06			
			X 12' R/L				
PSS4818	6	B/O	S.S. 304 2B. 11 JA 48 X 96	1008.00			
			X 4' X 8'				
PSS48186	11	B/O	S.S. 304 2B. 18 JA 48 X 96	748.00			
			X 4' X 8'				
PSS48208	3	B/O	S.S. 304 2B. 20 JA 48 X 96	147.00			
			X 4' X 8'				
	1	B/O	AL. HEX. 1 5/8"	1.00			
			X 10' - 12' R/L				
	1	B/O	06116 AL. SHEET .100"	1.00			
			X 4' X 12'				
	4	B/O	06116 AL. SHEET .040"	4.00			
			X 4' X 12'				

* Unités de mesure : CLB Cent (100) livres / Units of measure : CPI Cent (100) pounds / UN Unit / PI Pies / PC Pieds / Square feet

POIDS TOTAL
TOTAL WEIGHT

CONDITIONS :

LES MATÉRIAUX LIVRÉS ET FACTURÉS SONT À LA PROPRIÉTÉ DE "ACIER CAMP INC." JUSQU'À PAIEMENT COMPLET EN CASH. LES RISQUES DE PERTE OU DE DÉGRADATION DU MATÉRIEL SONT À LA CHARGE DU CLIENT. LA GARANTIE DE QUALITÉ DU MATÉRIEL EST LA MÊME QUE CELLE DU FABRICANT. L'ACHETEUR S'ENGAGE À RESPECTER LES CONDITIONS SUIVANTES : NET 30 JOURS DE LA DATE DE FACTURATION, À TOUT DÉFAUT D'EXÉCUTION L'UNE OU L'AUTRE DES OBLIGATIONS EN VERTU DU PRÉSENT CONTRAT ENTRAÎNE LA DÉCHÉANCE DU TERME ET PERMET AU VENDEUR, À SON CHOIX, DE RÉCLAMER TOUT SOLDE DU PRIX DE VENTE OU DE REPRISE LE BIEN VENDU. TOUTE RÉCLAMATION DOIT ÊTRE FAITE DANS LES CINQ JOURS SUivant PRÉSENTATION DE CE DOCUMENT. TOUTE MARCHANDISE ENDOMMAGÉE, ALTÉRÉE OU COUPÉE NE PEUT ÊTRE REPRISE. AUCUN RETOUR DE MARCHANDISE NE SERA ACCEPTÉ SANS NOTRE AUTORISATION. TOUTE MARCHANDISE RETOURNÉE EST SUJETTE À DES FRAIS DE MANUTENTION DE 25%.

CONDITIONS :

ALL SOLD AND DELIVERED MATERIALS REMAIN THE PROPERTY OF "ACIER CAMP INC." UNTIL PAYMENT IS MADE FULL, COMPLETE AND CASHED. ALL LOST MATERIALS ARE AT THE BUYER'S EXPENSE. ALL MATERIALS BEAR THE SAME WARRANTY AS GIVEN BY THE MANUFACTURER. THE BUYER HEREBY ACCEPTS TO RESPECT THE FOLLOWING CONDITIONS: NET 30 DAYS FROM BILLING DATE AND THE BUYER ACCEPTS TO PAY ADMINISTRATION CHARGES OF 2% PER MONTH OR 24% PER ANNUM ON ALL PAST DUE ACCOUNTS OVER 30 DAYS. ANY DEFAULT IN RESPECT WITH THIS CONTRACT WILL LEAD TO PAYMENT BY ACCELERATION AND PERMITS TO THE SELLER, AT HIS CHOICE, TO CLAIM FOR THE BALANCE DUE OR THE REPOSSESSION OF THE GOODS SOLD. ANY CLAIM MUST BE MADE WITHIN FIVE DAYS WITH THIS DOCUMENT ENCLOSED. ANY MERCHANDISE THAT HAS BEEN DAMAGED, CUT OR MODIFIED CANNOT BE RETURNED. ALL GOODS RETURNED MUST BE WITH OUR AUTHORIZATION AND ARE SUBJECT TO A 25% RESTOCKING CHARGE.

SOUS-TOTAL
SUB TOTAL

T.P.S.
G.S.T.

T.V.Q. / T.V.H.
G.S.T. / H.S.T.

TOTAL

PRÉPARÉ PAR / PREPARED BY
VÉRIFIÉ PAR / VERIFIED BY

LIVRÉ PAR / DELIVERED BY
HEURE / TIME

MARCHANDISE REÇUE EN BONNE CONDITION / MERCHANDISE RECEIVED IN GOOD CONDITION
A/Y M/M J/D
14/02/14

SIGNATURE DU CLIENT / CUSTOMER'S SIGNATURE

DATE

N° ENR. TPS / GST REG. N° R 135 534 717

N° ENR. TVQ / QST REG. N° 1 015 668 543

SCRIPTO-1071

METALLURGICAL TEST REPORT

Certificate: 892021 2

Date: 11/19/2013 Page: 1

Customer: 007035 510

Steel: 304

Finish: 2B

Your Order: 741198

NAS Order: PN 0032653 01

Corrosion: ASTM A262/10 A; 180Bend-OK

PRODUCT DESCRIPTION:

STAINLESS STEEL COIL, C.R. ANNEALED & PICKLED; UNS 30400
ASTM A240/13a, A480/13, A666/10; ASME SA240/11a, SA480/11a, SA666/11a
CHEM ONLY ON FOLLOWING ASTM: A276/13, A479/13a, A484/13a, A312/13
CHEM ONLY ON FOLLOWING ASME: SA312/11a, SA479/11a
AMS 5513J XMRK; MIL-8-5059D ANEND3 (X CROWN BEAS)
NACE MR0175/ISO 15156-3:2003 A, MR0103/07; Q08766D-A X MAG PERM
MIN. SOLUTION ANNEAL TEMP 1900F, WATER QUENCHED

REMARKS:

Mat'l is Free of Mercury Contamination. No weld repairs.
EN 10204:2004 3.1; RoHS 1 & 2 Compliant
Material is Free of Radioactive Contamination
NAS Steel Making Process: EAF, AOD, & Cont. Casting
Product Mfg. by a Quality Mgt. Sys. in Conf. w/ISO 9001
*Melted & Manufactured in the USA; Mat'l is DFARS Compliant
*Melted & Manufactured in the USA; Mat'l is DFARS Compliant

Product Id	Coil #	Skid #	Thickness	Width	Weight	Length	Mark	Pieces	Commodity Code
02K2B3 D	02K2B3 D		.1163	48.0000	17,120	COIL	13	1	74275694

CHEMICAL ANALYSIS CM(Country of Melt) ES(Spain) US(United States) ZA(South Africa) JP(Japan) Chemical Analysis per ASTM A751/08

HEAT	CM	C %	CR %	CU %	MN %	MO %	N %	NI %	P %	S %
K2B3	US	.0446	18.2150	.4605	1.7310	.3000	.0577	8.0205	.0310	.0015
SI %										
.2030										

MECHANICAL PROPERTIES

Product Id#	Coil #	UTS	2% YS	ELONG	Hard	Tail
		KSI	KSI	%-2"	RB	Hard
02K2B3 D	02K2B3 D	95.19	44.82	51.18	86.00	87.00

NAS hereby certifies that the analysis on this certification is correct. Based upon the results and the accuracy of the test methods used, the material meets the specifications stated. These results relate only to the items tested and this report cannot be reproduced, except in its entirety, without the written approval of NAS.

Technical
Dept. Mgr.

ERIC HESS

11/19/2013

ACTER CMPT INC. P.O. - 58948 S.O. - 325895





Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID PO22968

Purchase Order Date 2/11/2014

PO Print Date 2/12/2014

Page Number 3 of 8

Order From :

CAMPI STEEL
935 BOUL. DU HAVRE
VALLEYFIELD, QC J6S 5L1
CA

VC-CAM002

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 800 667 4248

Ship To Contact

Ship To Phone

Ship Via: Yours ppd

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 30

Currency

CAD

FOB

FCA - (Free Carrier)

6	M6063T5C.75X.75W.125	6063 CHANNEL.750 X.750 X.125w	3/21/2014	20.00		\$0.55	\$11.00
			Yes				
			3/21/2014				
	AS PER QUOTE 337114						

Line Total: \$11.00

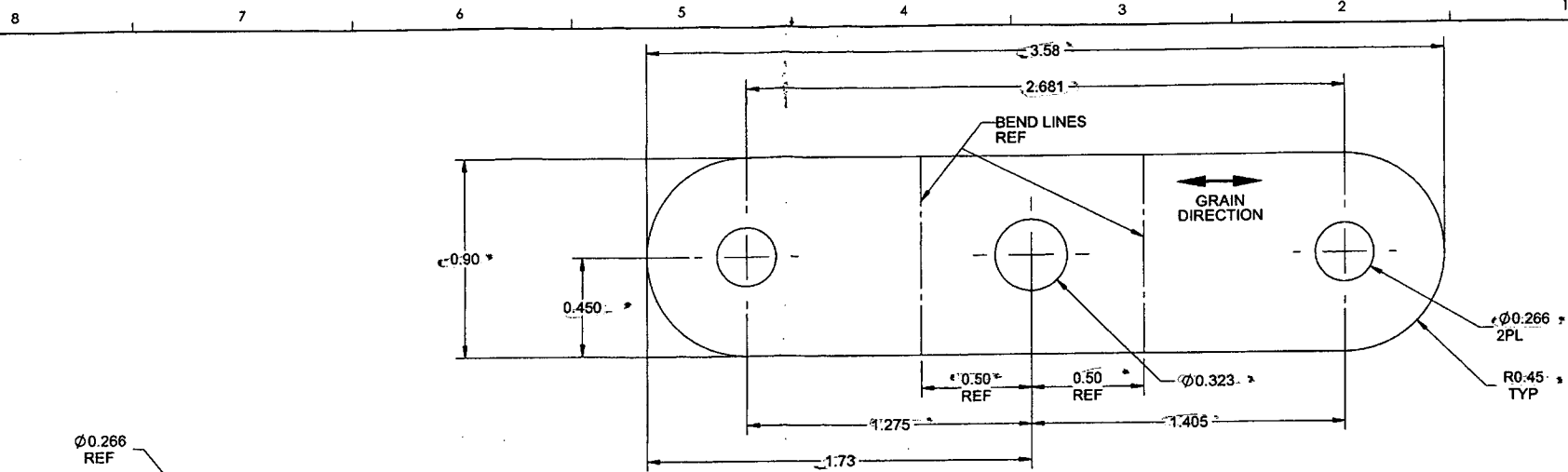
7	M304S11GA	304/316 0.125 Sheet	3/18/2014	192.00		\$12.70	\$2,438.40
			Yes				
			3/18/2014				
	MATERIAL: AISI 304/316 SS SHEET ANNEALED AS PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240						

Line Total: \$2,438.40

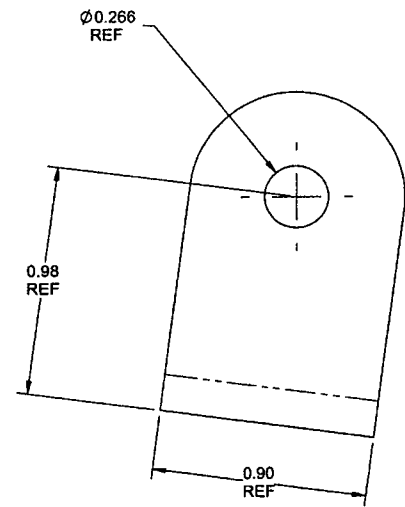
8	M304S18GA	304/316 .050 Sheet	3/18/2014	352.00		\$5.14	\$1,809.79
			Yes				
			3/18/2014				
	MATERIAL: AISI 304/316 SS SHEET ANNEALED AS PER MIL-S-5059 OR AMS 5513 (304) OR AMS 5524 (316) OR ASTM A240 OR ASME SA240						

PO Instructions: Procurement Quality Clauses

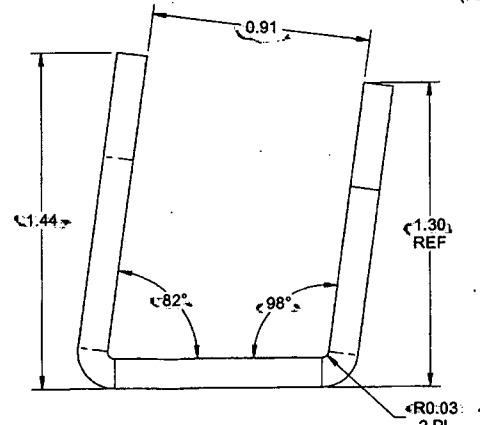
A005 right of entry
A012 chemical and physical test report
A016 personnel qualification
A017 raw material identification (as applicable)
A026 certification of material conformance
A041 quality management system
A042 dart



D5287-1F CLEVIS
(FLAT PATTERN)



VIEW A-A



D5287-1 CLEVIS

RELEASED
2015-07-20
EEN 15-07

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET PER MIL-S-5059 OR AMS 5513 OR AMS 5524 OR ASTM A240 OR ASME SA240
 - 2) FINISH: NONE
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
 - 7) WEIGHT: 0.10 lbs

APPROVED

A		NEW ISSUE		DB	15.07.09
REV.	DESCRIPTION			BY	DATE
DESIGN	DB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA			
DRAWN	DB				
CHECKED	AP	DRAWING NO.	REV. A		
MFG. APPR.	JLM	D5287	SHEET 1 OF 1		
APPROVED	WM	TITLE	SCALE		
DE APPR.	DS	CLEVIS	NTS		
DATE	15.07.09	COPYRIGHT © 2015 BY DART AEROSPACE LTD			
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